

Work Order ID 152065***152065***

Page 1

Wednesday, October 19, 2016 1:39:13 PM

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ground Handling Lug
Start Date: 10/19/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference: POWDERCOAT WHITE *Re-work*
Approvals: Process Plan: *W* Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								

130

0.02

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr
2-Form using DT8204 as per Dwg D3405
3- use DT9681 to check if correct forming

0.08

N/A

⑫ 16-10-24
done on w/o 149209

DAS

9

9-88

180

0.00

180

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

PULL FROM W/O 149207
12 X D3405-043 UNPAINTED
POWDER COAT GLOSS WHITE
PER QSI005 *1134798*
(TOO MANY MADE FOR DRAB GREEN ON W/O 149207)

0.06

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40
400°
12:10

12 φ 16-10-25

DAS

34

9-88

Work Order ID 152065

Wednesday, October 19, 2016 1:39:13 PM

152065

Page 2

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Ground Handling Lug
Start Date: 10/19/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference: POWDERCOAT WHITE

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				(12)			DAS 38 9-89 OCT 25 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>81529</u> Memo IDENTIFY USING NEW B/N	0.00 0.20				12x			DAS 26 9-89 OCT 25 2016
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							16/10/26 DAS 21 9-89 OCT 26 2016

Picklist Print

Wednesday, October 19, 2016 1:39:12 PM

Page 1

Work Order ID: 152065

152065

Parent Item: D3405-043

D3405-043

Parent Item Name: Ground Handling Lug

Start Date: 10/19/2016

Required Date: 10/19/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3405-043

Manufactured No

Each 16.0000

12

D3405-043

B149207 (12)

Ground Handling Lug

Location

Loc Qty

Loc Code

st529

16

147906

6

148665

10

SPLIT

Work Order ID 149207 - ~~27551~~
July 21, 2016 3:21:59 PM

149207

~~DRAB GREEN~~ Page 1

Item ID: D3405-043
Revision ID:
Item Name: Ground Handling Lug
Start Date: 9/20/2016
Required Date: 9/30/2016
Reference:

Start Qty: 10.00
Req'd Qty: 10.00
6 dm *10* 6 dm
10 *10*

Accept

N900040100
Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

JUL 25 2016

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								

100

100

Waterjet
FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3405
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

0.00

0.17

152065

22

DAS
50
9-89

110

110

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.03

REFERENCE ONLY

22

DAS
50
9-89

120

120

QC
Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.03

22

JUL 29 2016

Work Order ID 149207

July 21, 2016 3:21:59 PM

149207

Page 2

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ground Handling Lug
 Start Date: 9/20/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/30/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.02							
130	NC BRAKE				DAS	22			AUG 17 2016
Brake NC	Memo	0.07			30				
Brake NC	1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming				90				
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(22)			
QC	Memo	0.03							AUG 18 2016
Quality Control									
150	Weld per dwg A/R S.S. rod Batch: <u>116577</u>	0.00							
150	Large Fab					22			16-09-01
Large Fab	Memo	0.23							ML
Large Fab	Weld as per Dwg D3405 use DT8484 Identify as D3405-043								

Work Order ID 149207

Monday, July 25, 2016 9:00:59 AM

149207

Page 3

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ground Handling Lug
 Start Date: 9/20/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/30/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160									
QC	Memo	0.03				(27)	160902		DAS 9 9-89
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.03				(22)	160902		DAS 9 9-89
Quality Control									
185		0.00							
185									
SprayPaint									
Spray Painting	Memo PRIME B SPRAY PAINT DRAB GREEN B	0.00							

N/A

close w/o > pull to new w/o
 for 12 to powdercoat white
 w/ 16-10-19 (Too many made for
 Drab Green on this w/o)

152065

Work Order ID 149207

Monday, July 25, 2016 9:01:12 AM

149207

Page 4

Item ID: D3405-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Ground Handling Lug

Stop ***NS2***

Start Date: 9/20/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
195 *195* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.17							
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							

N/A

u 16-019
12

Picklist Print

July 21, 2016 3:21:59 PM

Page 1

Work Order ID: 149207

Parent Item: D3405-043

Parent Item Name: Ground Handling Lug

149207

D3405-043

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	38.0000	1	10			

D3404-1

GHW/ Lug

Location

WA001

147973

Loc Qty

38

Loc Code

22

16-08-01

1/31

M304S11GA

Purchased

No

150

sf

47.8369

0.154

1.621053

**

PR 2016/07/29

M304S11GA

304/316 0.125 Sheet

Location

MAT020

M129545

M129972

M134284

TPI

M134604

Loc Qty

37.52998

27.33998

7.4

2.79

10.3069336

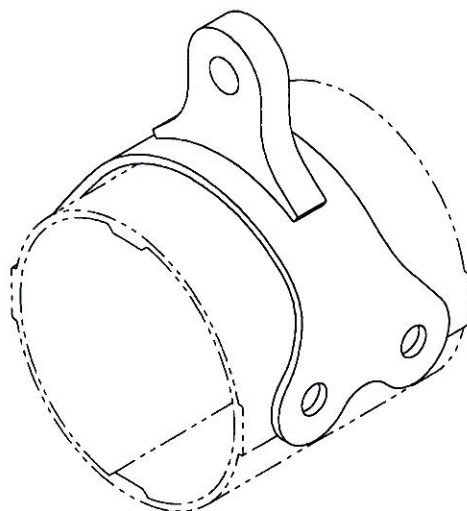
10.3069336

Loc Code

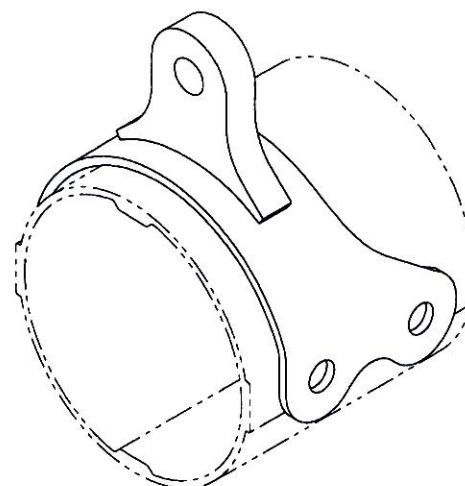
3

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SECRETARY
KENT
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WORK ORDER
149207 ULS
1607-25

RELEASED
08/12/18 MJP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR .1 & .3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	